Work Order ID 57275

Page 1

Wednesday, March 31, 2010 11:56:05 AM

Item ID:

D3912-5

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Eyebolt Plate 3/31/2010

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 4/5/2010

MF Process Plan:

**Revision Nbr** 

Date: (()(3, 3) Tooling:

Date:

Start

QC: \_\_\_\_\_

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

Operation Description

Set Up/ **Run Hours** 

Draw Number

Draw Rev.

Plan Qty Code

Reject Qty

Accept

Run

Reject Number

Insp. Stamp

**Draw Nbr** 

D3912 Α

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D3912 Prog Rev: Dwg Rev:

0.00

0.00

惠 10-3-31

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

W/O:			WO	RK ORDER CHANG	iES				Ç.	
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Yes	No DO	QA:	Date: _		
	Resolution:		Disposition	1:	_ QA: N/C C	QA: N/C Closed: Date				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC	· · · · · · · · · · · · · · · · · · ·		ion B	Veri	fication	Approval	Approva	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Se	ction C	Chief Eng	QC Inspecto	
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								<u>ا</u>		
								J		

Page 2

Item ID:

Wednesday, March 31, 2010 11:56:05 AM D3912-5

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Eyebolt Plate** 

**Start Date:** 

3/31/2010

**Start Qty: 12.00** 

Required Date: 4/5/2010

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop

Sequence ID/

**Work Center ID** 

120

Quality Control

Operation **Description** 

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

130

140

Packaging

Identify as per dwg & Stock Location: 05%

0.00

Packaging

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10 lo4 106 754 MG

Quality Control

Dart Ae	rospace	Ltd				-			, e ,
W/O:			WC	ORK ORDER CHANGES					<u> </u>
DATE	STEP	PRO	CEDURE CHA	77	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			-			•			
Part No		PAR #:							
	Re	esolution:	Disposition	n: Q	A: N/C CI	osed:		Date: _	
NCR:		·	VORK ORDI	ER NON-CONFORMANC	E (NCF	R)			1.1 1.2 (1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verific Secti		Approval Chief Eng	Approva QC Inspecto
									-

## **Picklist Print**

Wednesday, March 31, 2010 11:56:04 AM

Work Order ID: 57275

Parent Item: D3912-5

Parent Item Name: Eyebolt Plate

IPP RevA: new issue DD 09.11.17 verified by:EC

Start Date: 3/31/2010

Required Date: 4/5/2010

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M304S11GA		Purchased	No			100	sf	41.4194	0.6474	1	1310-3-31	

304/316 0.125 Sheet

Comments:

Warehouse Loc Oty Loc Code Location

Main Warehouse

MAT19 41,4194

112663 41.4194



Dart Ae	rospace	Ltd							¢ ,
W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,,,,,						
Part No		PAR #:	Fault Cat	egory:	NCR: Ye	es No [	DQA:	Date:	
	Resolution:								
NCR:		1	WORK ORI	DER NON-CONFORMA	NCE (N	CR)			
		Description of NC		Corrective Action Section	n B	Vo	rification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& ∣ <sub>S</sub>	ection C	Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	57775
Description: EYEBOIT PLATE	Part Number:	D3412-5
Inspection Dwg:D3912-5, Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

i	rawing mension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø	.129	4.005-001	,131	y			
\$	.757	+ .006001	- 360	×			
(	1.500	£ .010	1,499	1			
	.500	4 010	1499	X			
	1375	47 010	376	M			
	.517	4_ 00	.514	8			
	1.006	4 .00	1,601	*			
	1,500	000, - 050, +	1,501	Ser .			
	3.15	7/ .030	3,145	8		,	
	,38	4/ -320	387	8		,	
	-24	-1BO	.753	75			
	3,65	+L 30	3,653	8			
	3.69	7 .030	3,69	<i>y</i> -			
	2.00	4/ .030	5,010	y			
	. છિંદ	TL -010	.118	7			
				<u> </u>			

Measured by:	8	Audited by:	Prototype Approval:	
Date:	10-3-31	Date: 10/04/61	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

0.800+0.000 - 2.30 Ø0.129 THRU 1.500 4 PL 0.500 PITCH 0.400 0.50 REF 1.00 0.750 +0.000 0.500 R0.13 R0.125 TYP 0.516+0.015 0.63

**D3912-3 EYEBOLT BLOCK** 

1.500 . 3/6 0.500 PITCH R0.13 ا0.375ك TYP 629 387 186 0.25 0.517 1.000 1,057 1.500+0.020 2.00 1.629 REF **+** - **+** - **+**-,064 Ø0.129 Ø0.257 8 PL 0.125 2 PL -1285 REF 3.65 3.69 REF

3.15 1.625

**D3912-5 EYEBOLT PLATE** 

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3912 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE EYEBOLT RECEIVER ASSY DE APPR. NTS COPYRIGHT © 2010 BY DATA AEROSPACE LTD
THE DOCUMENT BY PRIVATE AND CONFEDENCE AND IN BUTTLED ON THE ESPRESS CONDUCTION TO THE WEST FOR ANY PRIVATE ON COMPANIES. THE TO THE WINDS AND THE PRIVATE OF COMPANIES. THE TOTAL AND THE PRIVATE OF THE PRIVA DATE 10.03.04

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

8

D

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

D

Dart Ae	rospace	Ltd								
W/O:			WC	ORK ORDER CHA	ANGES					#?
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
				· · · · · · · · · · · · · · · · · · ·						
Part No	•	PAR #:	Fault Cate	gory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	n:	QA	: N/C CI	osed:		Date:	
NCR:		V	VORK ORDI	ER NON-CONFO	RMANCE	(NCF	(1)			
DATE	STEP	Description of NC		<b>Corrective Action</b>	Section B		Verific	cation	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign 8 Date		ion C	Chief Eng	QC Inspecto
									-	